

# Work Order ID 65554

January 19, 2011 1:40:44 PM



Page 1

Item ID: D3167-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 1/20/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: UMF Date: 11-01-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3167	Rev A1

120 0.00



FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet Cut Blank as per File D3167-1\_BLANK

11-1-20

(4)

130 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I Memo 0.00

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit  
1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA285 and Dwg D3167  
3-Deburr

11/02/03

11-1-20

4

140 0.00



QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00

Quality Control

11/02/03

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65554

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Item ID: D3167-1

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Setup Start



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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00	B.A	11/02/03		4	0		
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Copy*

*11/02/07*

*11/02/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 65554



Parent Item: D3167-1



Parent Item Name: Bearpaw


Start Date: 1/20/11

Required Date: 1/28/11

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	204.8794	3.6	14.4			



1811-1-20

### Location

### Loc Qty

### Loc Code

MAT

204.8794

114624

5.2734

115325

15.506

115955

38.8

116281

13

116554

132.3

116554

④

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 65554
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3167-1
<b>Inspection Dwg:</b> D3167	<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	.051 X 45°	—		Vern	ML-7
B	5.80	+/-0.030	5.799	—		"	"
C	0.25 x 45°	+/-0.030	.265 X 45°	—		"	"
D	R0.25	+/-0.030	R.250	—		Radi-gage	REF
E	0.200	+/-0.030	.195	—		Vern	ML-7
F	0.250	+/-0.010	.255	—		"	"
G	0.625	+/-0.030	.630	—		"	"
H	0.375	+/-0.010	.385	—		"	"
I	0.950	+0.030/-0.010	.960	—		"	"
J	3.21	+/-0.030	3.210	—		"	"
K	19.00	+/-0.030	19.00	—		M-tape	ML-2
L	Ø0.260	+0.005/-0.000	Ø.260	—		Vern	ML-7
M	Ø0.93	+/-0.030	Ø.935	—		"	"
N	0.30	+0.030/-0.000	.315	—		"	"
O	0.375	+/-0.030	.377	—		"	"
P	7.23	+/-0.030	7.230	—		M-tape	ML-2
Q	4.54	+/-0.010	4.540	—		"	"
R	2.00	+/-0.030	2.00	—		"	"
S	12.000	+/-0.010	12.000	—		"	"
T	6.000	+/-0.010	6.000	—		"	"
U	23.75	+/-0.030	23.75	—		M-tape	ML-2

<b>Measured by:</b> <i>ML</i>	<b>Audited by:</b> M.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/02/03	<b>Date:</b> 11/02/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF <i>RF</i>	<i>#</i>

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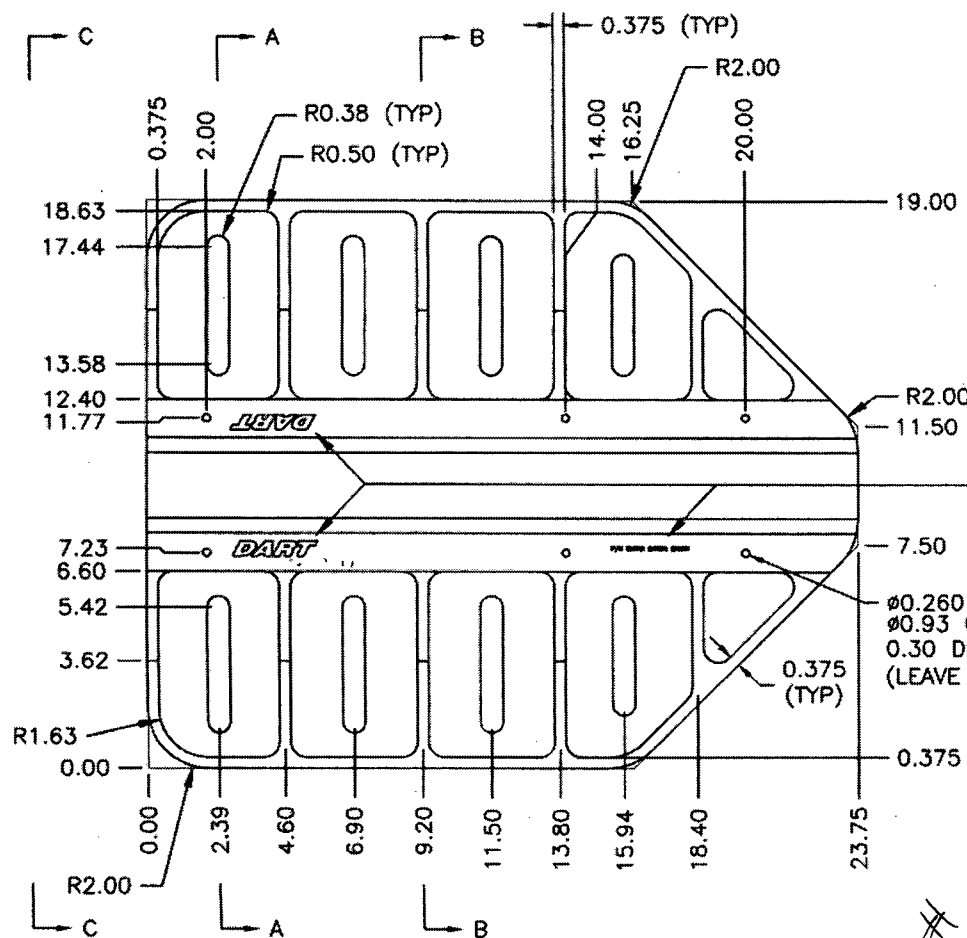
**NOTE:** Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3167	SHEET 1 OF 2
02.10.08		TITLE	SCALE
		BEARPAW	1:6
A	02.10.08	NEW ISSUE	
A1	02.12.17	5.80 WAS 5.50	

RELEASED  
02.10.25



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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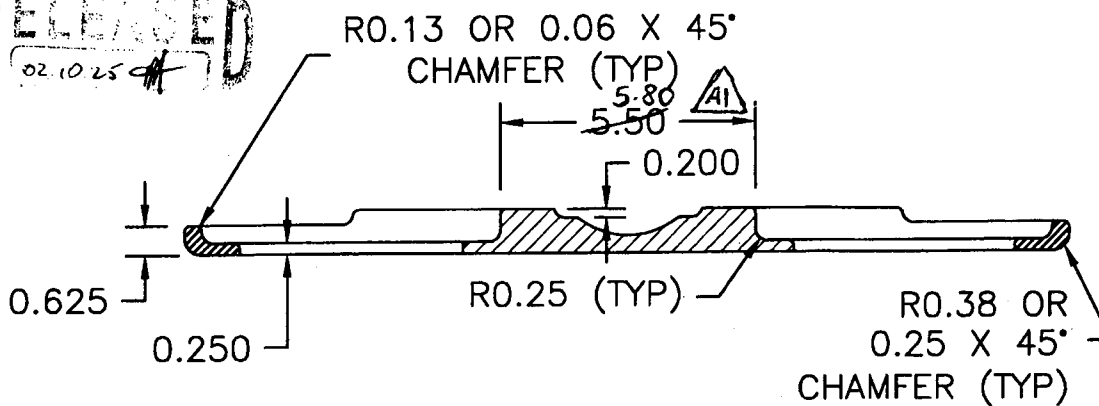
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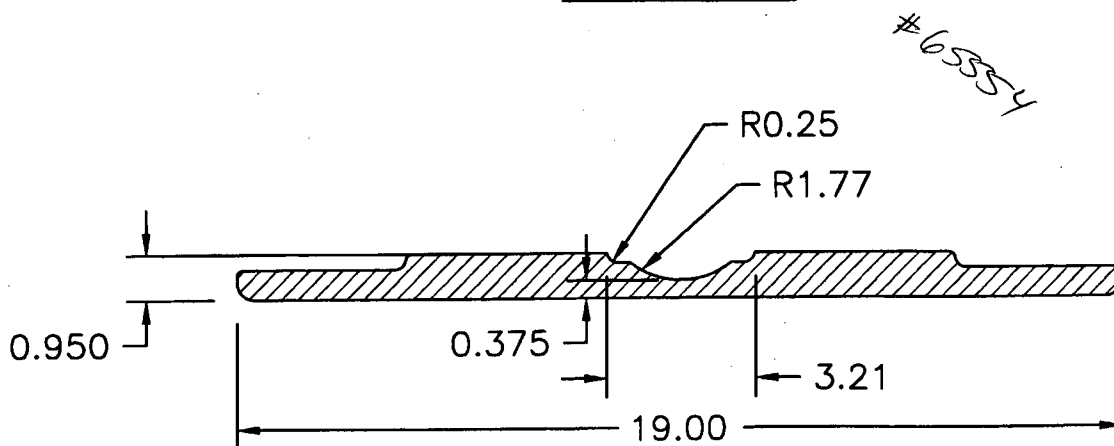


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CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

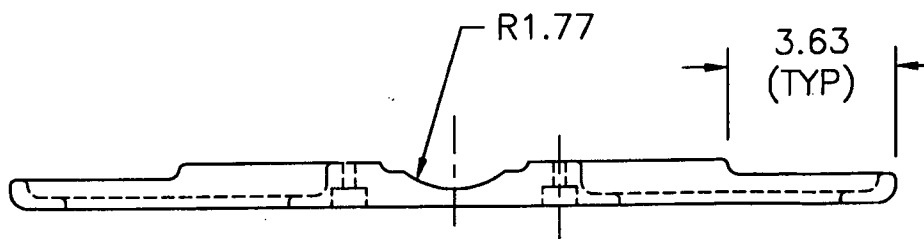
RELEASED  
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

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